









Work Order ID 61936

Friday, September 10, 2010 9:44:06 AM

PRELIMINARY ISSUE


Page 1

Item ID:	D4172-044	Accept		Setup	Start	
Revision ID:	PRELIM					
Item Name:	Z-Shape Section Assembly, RH				Stop	
Start Date:	9/10/2010	Start Qty:	1.00			
Required Date:	9/17/2010	Req'd Qty:	1.00			
Reference:				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:		Date:	10-9-13	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4172	PA2	10.09.16							

100		0.00							
									
Small Fab	Memo	0.00							
Small Fab	1- Transfer drill holes, deburr and assemble as per dwg								

BT 10-09-21


(Pto)

110	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

inspected to PA2

Day only

8/10/12/22 (Pto)

120	Identify as per dwg & Stock Location:	0.00							
									
Packaging	Memo	0.00							
Packaging									

BT 10-09-21

W/O: 61936		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-09-22	100	rivets along angled top piece installed facing outward non permanent change ACCEPTABLE 10/09/22	BT	10-09-22	1	10/09/22	

Part No: D 4172-044 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-09-22	100	1 rivet not seated properly		remove + re install new rivet 25213-4-04 on 104191 N/A	BT 10-09-22			

NOTE: Date & initial all entries

Work Order ID 61936

Friday, September 10, 2010 9:44:06 AM



Page 2

Item ID: D4172-044

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Z-Shape Section Assembly, RH

Start Date: 9/10/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/29

11009.23

POSITIVE RECALL

EFFECTIVE 10-9-13 AUTH 11

RELEASED 10-09-29 DATE 10-09-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, September 10, 2010 9:44:10 AM

Work Order ID: 61936

Parent Item: D4172-044

Parent Item Name: Z-Shape Section Assembly, RH







Start Date: 9/10/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status												
D4172-1 		Manufactured	No			100	Each	0.0000	1	1															
Supporting Plate						B61938				7C		10-09-21													
D4172-4 		Manufactured	No			100	Each	0.0000	1	1															
Support Angle						B61940				8T		10-09-21													
D4172-45 		Manufactured	No			100	Each	0.0000	1	1															
Support Angle						B 61941				8T		10-09-21													
CR3213-4-04 		Purchased	No			100	Each	0.0000	46	46															
Rivet						B 104291				8T		10-09-21													
MS20426AD3-45 	MS20426AD3-45	Purchased	No			100	Each	6,540.000	22	22															
RIVET						M 4179				8T		10-09-21													
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST316</td><td>6540</td><td></td></tr><tr><td>04374</td><td>2540</td><td></td></tr><tr><td>110398</td><td>4000</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST316	6540		04374	2540		110398	4000	
Location	Loc Qty	Loc Code																							
ST316	6540																								
04374	2540																								
110398	4000																								
MS21075L4 or MS21075L4N 	MS21075L4N	Purchased	No			100	Each	0.0000	11	11															
Nutplate						115708				8T		10-09-21													

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -044	P/N	DESCRIPTION
	X	D4172-044	Z-SHAPE SECTION ASSY, RH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-4	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-4	RIVET
6	11	MS21075L4	NUT PLATE

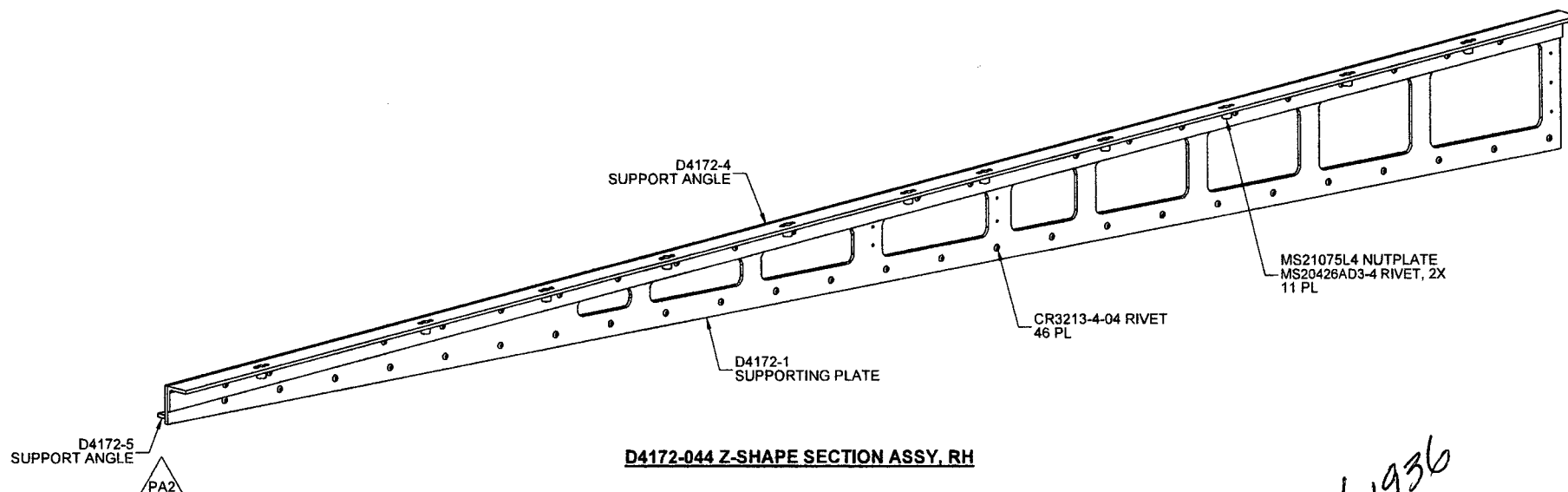


D

C

B

A



D

C

B

A

61936

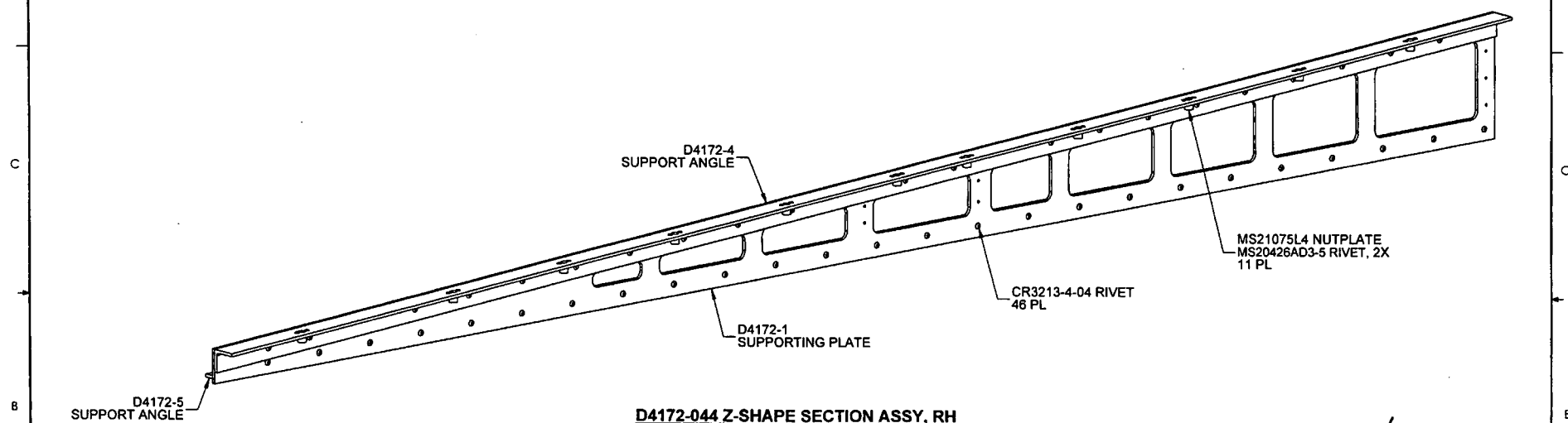
PRELIMINARY ISSUE

10.09.15

NOTES:
 1) MATERIAL: NONE
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 2.14 lbs

DESIGN	<i>h</i>	DART AEROSPACE LTD	
DRAWN	<i>h</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4172	SHEET 3 OF 7
APPROVED		TITLE	SCALE
DE APPR.		POD MOUNTING FRAME ASSY NTS	
DATE	10.09.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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DESIGN		DART AEROSPACE LTD
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MFG. APPR.		D4172 SHEET 3 OF 7
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